

Date: Thursday, 3/23/2006 3:44:54 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTECTOR AFT RH
Job Number : 26356	
Estimate Number : 11235	
P.O. Number : N/A	Part Number : D32814
This Issue : 3/23/2006 S.O. No. : N/A	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 25123	Material : N/A
Written By : SEE COMMENT BELOW	Due Date : 4/10/2006 Qty: 20 Um: Each
Checked & Approved By : [Signature] 06.03.24	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASING

Issue P/O: 00000889

Description: Floor Protector Aft RH

Possible Supplier: Delastek

Certificate of Conformity is required

2.0	D32814P	Floor Protector, Aft RH
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Floor Protector, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Identify and Stock

Location: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *PD* Date: 06/04/19

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 3/23/2006 3:44:54 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROCTOR AFT RH

Job Number: 26356

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

SD 06/04/19 *(SD)*

Job Completion



12 06/04/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

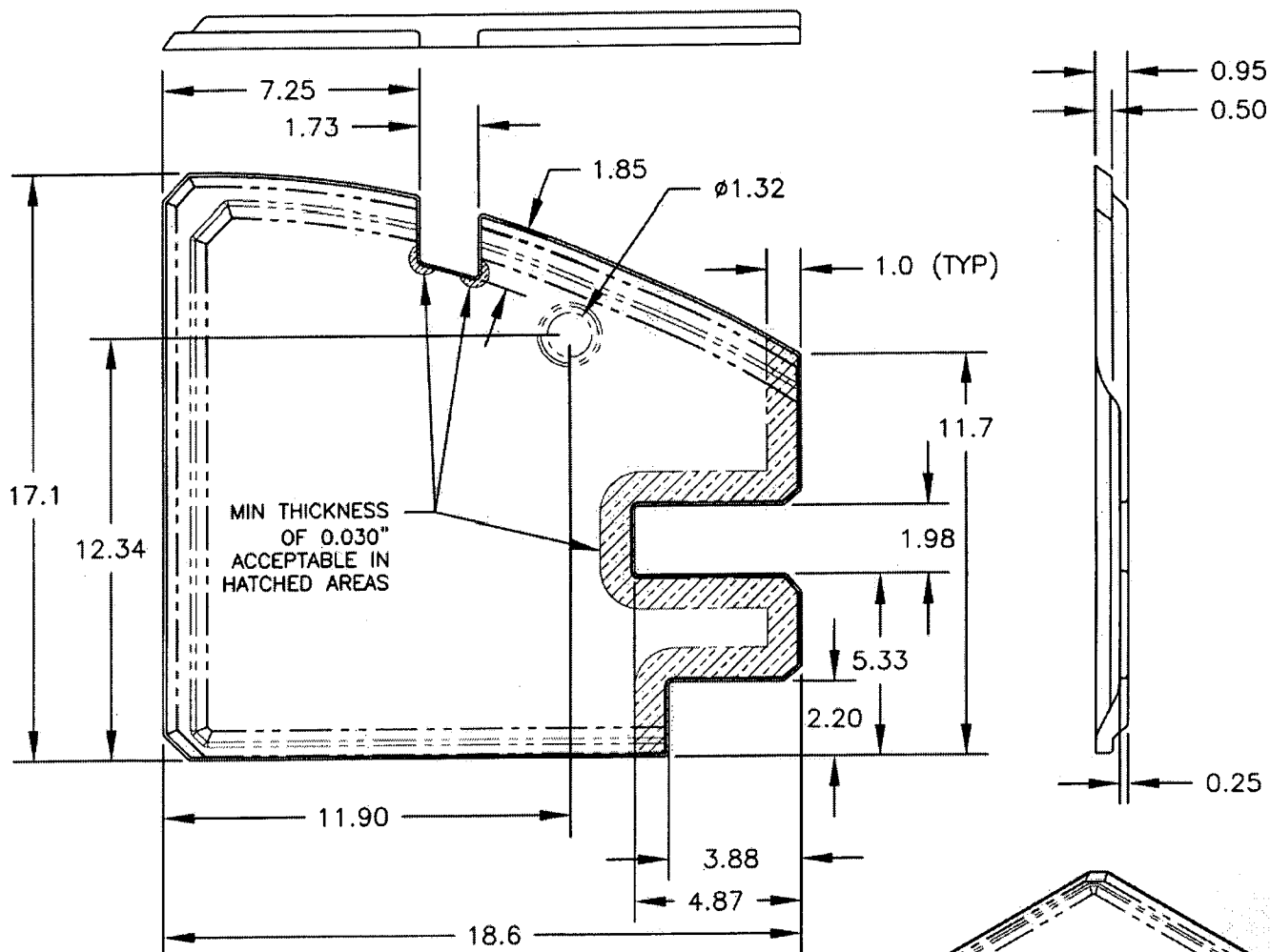
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



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CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01

D3281-1 FLOOR PROTECTOR, FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

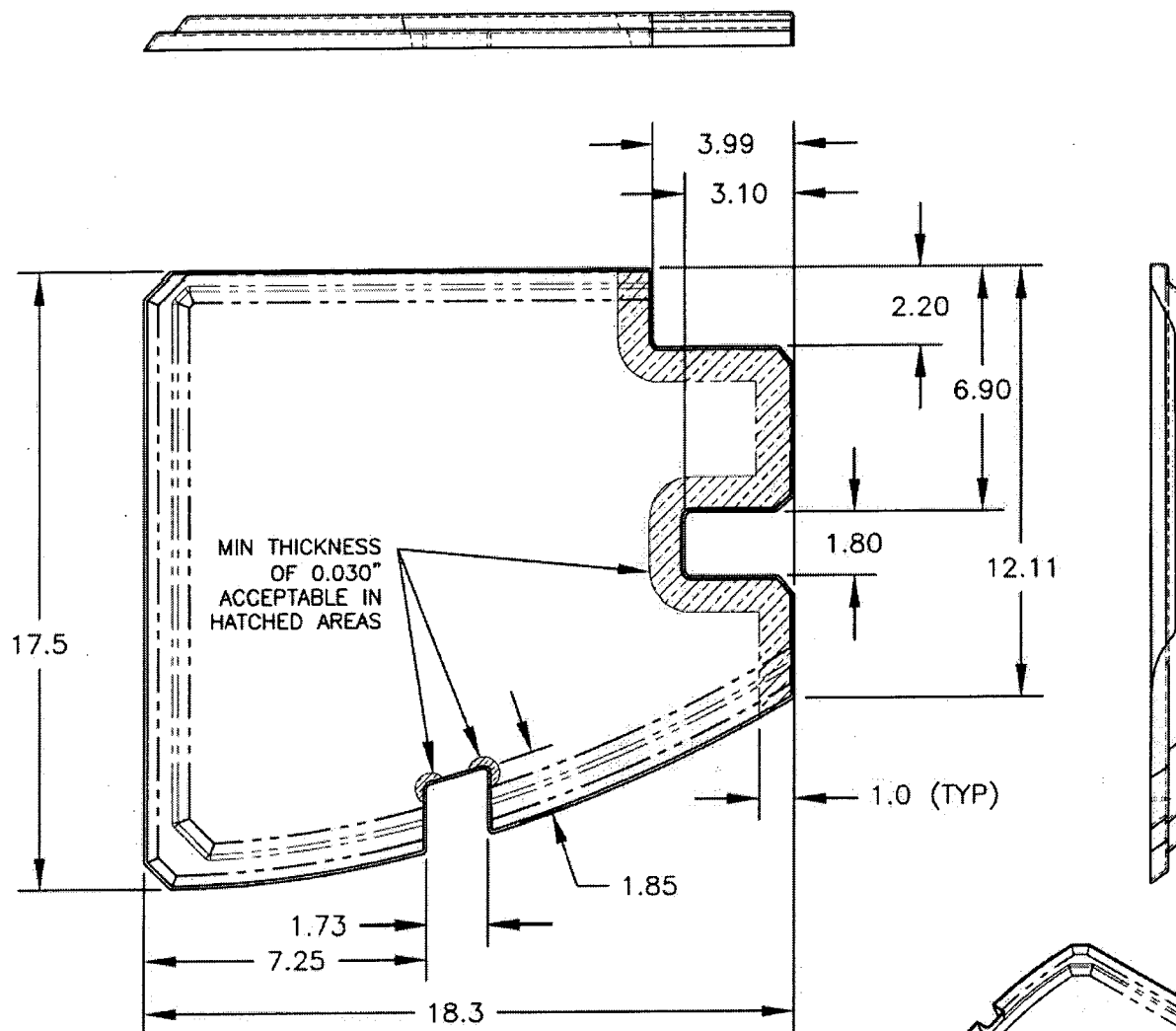
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WORK ORDER
NO. 26356

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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5

**RELEASED**
05.12.01 *[Signature]***D3281-2 FLOOR PROTECTOR. FWD RH**

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

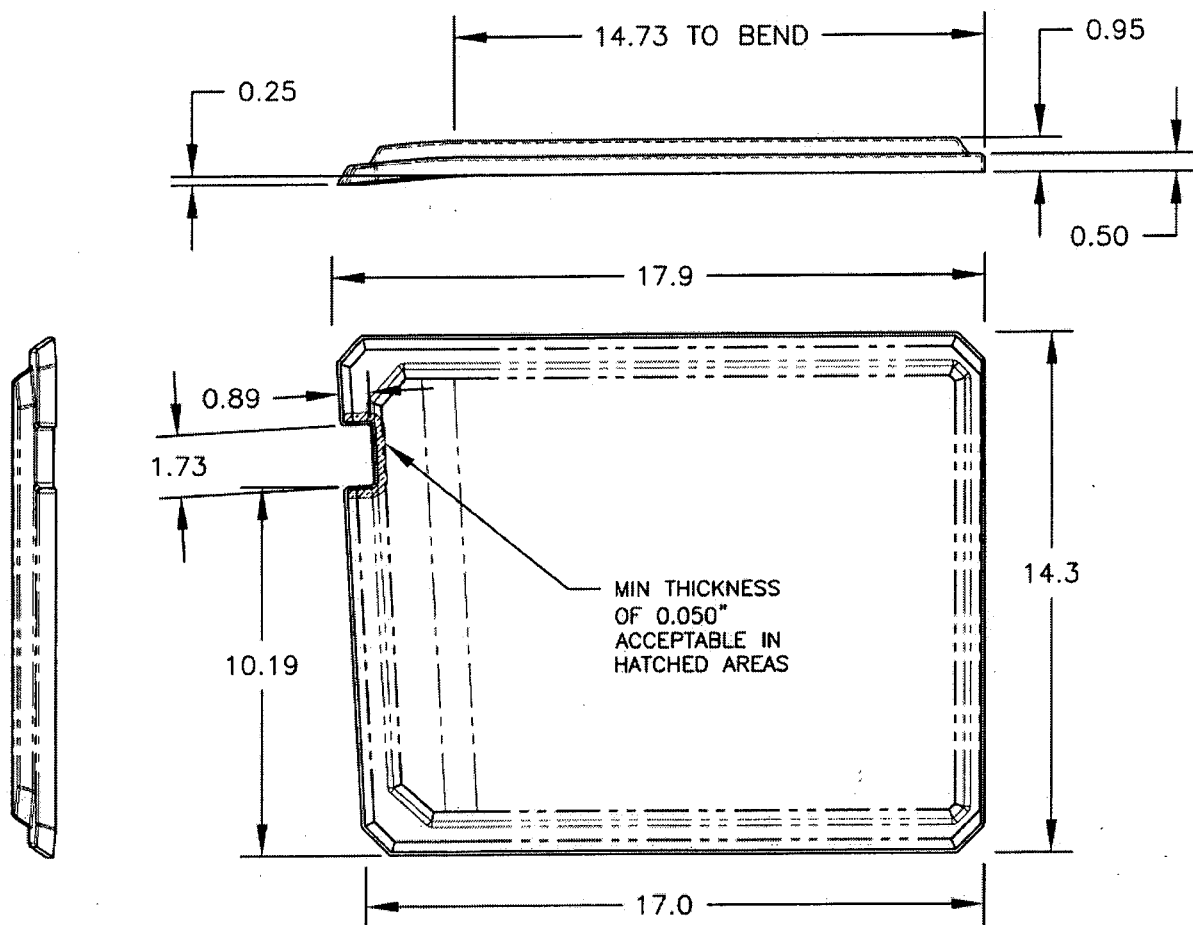
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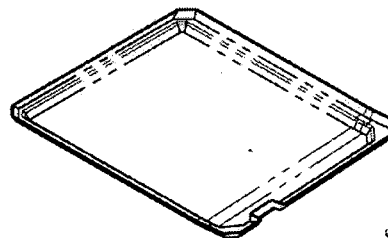
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DATE 05.11.25	TITLE FLOOR PROTECTOR		SCALE 1:5



RELEASED
05.12.01. *[Signature]*



D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

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Feuille de Procédé

Client	: DART	Dart Aerospace Ltd.	Nom Dessin	: FLOOR PROTECTOR AFT, LH	
Numéro Job	: 34176		Numéro Article	: DKC134-0047	
Numéro Soumission	: 2386		Numéro Dessin	: D3281	
Numéro B.A.	:		Projet Numéro	: DKC134	
Cette fois	: 2006-03-30	No. B.V. :	Révision dessin	: B	
Prsht Rev.	: NC		Matériel	: F6006	
Prem. fois	: - -	Type :	Date Due	: 2006-04-07	Qté: 20 Udm: UNITE
Job précédente	: 32266				
Écrit par	:				
Vérifié & Approuvé par	:				
Commentaires	:	N° de pièce: D3281-4			
		Process Sheet Rév.: 00			

Produit additionnel

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
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1.0	APL0016	Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.
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Commentair Qty.: 0.167 UNITE(s)/Unit T
Lexan F6006 Noir N° 700 48" x 9

APL0016

Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

Bon achat: 5327
SÉCHAGE / ANEALING

N° de Lot:

2.0	SÉCHAGE/ ANEAL
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Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.
Inscrire sur la charte de température le numéro de Job du matériel au séchage.
de cuisson: 4931

3.0	PRÉPARATION 3	PRÉPARATION DU MATÉRIEL DART
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Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 21 Date: 11-4-06 Sceau:

Quantité: Date: Sceau:



Client: DART Dart Aerospace Ltd.
Numéro Job: 34176Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description:

4.0

THERMOFORMAGE2

THERMOFORMAGE DES PIÈCE DART

Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECESFaire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le
thermoformeur 4' x 8'.

F.O: 11/04/02



Autocontrôle du lot de pièce thermoformées.

Quantité: 21 Date: 11-4-02 Sceau: [Signature]

Quantité: _____ Date: _____ Sceau: _____

5.0

TRIMAGE 3

TRIMAGE COMPOSITES DART

Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DARTFirst stuff retarded
MeetingNS
12/04/02

Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 21 Date: 12-4-02 Sceau: [Signature]

Quantité: _____ Date: _____ Sceau: _____

6.0

INSPECTION 3

INSPECTION PIÈCE DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 21 Date: 13/04/02 Sceau: [Signature]



7.0

IDENTIFICATION4

IDENTIFICATION PIÈCES DART

Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Client: DART Dart Aerospace Ltd.
Numéro Job: 34176

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-4

N° de Job: _____

Date de fabrication: _____

Sceau d'inspection.

Quantité: 20 Date: 12/04/06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE




Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton
identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication: _____

N° de job: _____

Quantité: 21 Date: 13/4/06 Sceau: 

Quantité: _____ Date: _____ Sceau: _____